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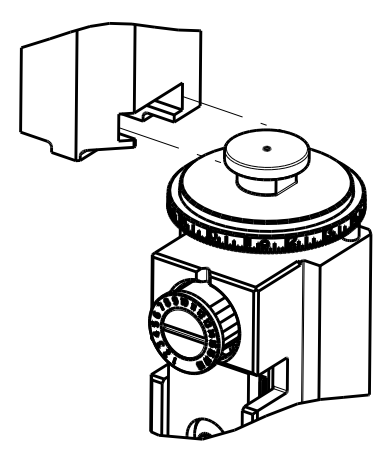
RELEASED FOR PUBLICATION

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ATLANTIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2266503-1

REVISION

C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL

PART
NUMBER

2266503-2

REVISION

C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

PNEUMATIC

PART
NUMBER

2266503-5

REVISION

C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

SERVO
LATCH PLATE⁴

PART
NUMBER

2266503-6

REVISION

C

DESCRIPTION

NON-CRIMP HEIGHT ADJUST

FEED TYPE

SERVO
LATCH PLATE⁴¹²

PART
NUMBER

2266503-7

REVISION

C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

NONE

PART
NUMBER

7-2266503-7

REVISION

A

DESCRIPTION

CRIMP TOOLING KIT

FEED TYPE

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm [1.00]	F
INSUL	3.30 mm [1.30]	O

APPLICATOR INSTRUCTIONS
408-10389

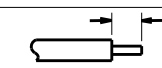
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 2.5mm CONTACT

WIRE STRIP LENGTH

4.90-5.60 mm [1.93-.220 IN]



INSULATION DIAMETER RANGE

Ø1.90-3.00 mm [1.075-.118 IN]

TERMINAL APPLICATION SPECIFICATION

(A)114-18020

(B)114-18040

TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 929964-1	(A) 929971-1	(A) 929971-8	(B) 929987-1
(A) 1-929964-0	(A) 929971-7		(B) 929987-4

WIRE SIZE





CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING



2.50mm2	1.97+/-0.03 [1.078+/-0.001]	4.0
2.00mm2	1.82+/-0.03 [1.072+/-0.001]	5.5
1.00mm2 + 1.00mm2	1.82+/-0.03 [1.072+/-0.001]	5.5
1.50mm2	1.67+/-0.03 [1.066+/-0.001]	7.2
0.50mm2 + 1.00mm2	1.67+/-0.03 [1.066+/-0.001]	7.2
1.25mm2	1.60+/-0.03 [1.063+/-0.001]	8.0

1

RECOMMENDED SPARE PARTS

2

GREASE BEARING SURFACES LIGHTLY

3

LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266503-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266503-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266503-5
SERVO FEED WITH "NON-CRIMP HEIGHT ADJUST": 8-2266503-6

5

ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.
FOR -6 ONLY APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 37.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 35 & 252.

8

MAGNET, ITEM 166 MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON THE BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

WHEN ASSEMBLING A NON CRIMP HEIGHT ADJUST APPLICATOR (-6) USE SHIMS FROM ITEM 260 TO ACHIEVE A NOMINAL SHIM HEIGHT OF 3.83.

13

FEED ADJUSTMENT REQUIRED WHEN SWITCHING BETWEEN (A) SPEC AND (B) SPEC TERMINALS.

APPLICATOR STYLE CONVERSION CHART

CONVERT TO	PART NUMBERS REQUIRED					
PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
SERVO LATCH PLATE	2119951-1	-	8-2266503-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266503-4	-	-	-
MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-
SERVO LATCH PLATE	2119951-1	-	8-2266503-5	1901094-3	-	2168400-6 (QUANTITY 2)
SMART APPLICATOR	2161326-1	-	8-2266503-4	-	-	-
MECHANICAL FEED	2119949-1	1338683-8	5-18022-5	2119653-1	-	-
PNEUMATIC FEED	2119950-1	1338683-8	5-18022-5	2119641-1	2119799-1	2063440-1
-	-	-	-	-	-	-
-	-	-	-	-	-	-
-	-	-	-	-	-	-

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4

(Pacific version shown on sheets 3 of 4 & 4 of 4)

LOC

A

DIST

66

REV

1

DATE

03OCT2014

CHK

R.O.WILSON

APVD

T.L.FLIN

NAME

Ocean Side Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2266503

RESTRICTED TO

-

CUSTOMER ACCESSIBLE PRODUCTION DRAWING

SCALE

1:2

SHEET

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OF

4

REV

C

REVISIONS

REV	DATE	DESCRIPTION	BY	APP
A	12NOV2014	RELEASED	RW	TE
B	24AUG2016	ECR-16-012083	RS	LZ
C	23NOV2016	ECR-16-016619	TB	TE
C	07MAR2018	ECR-18-003488	FL	TE

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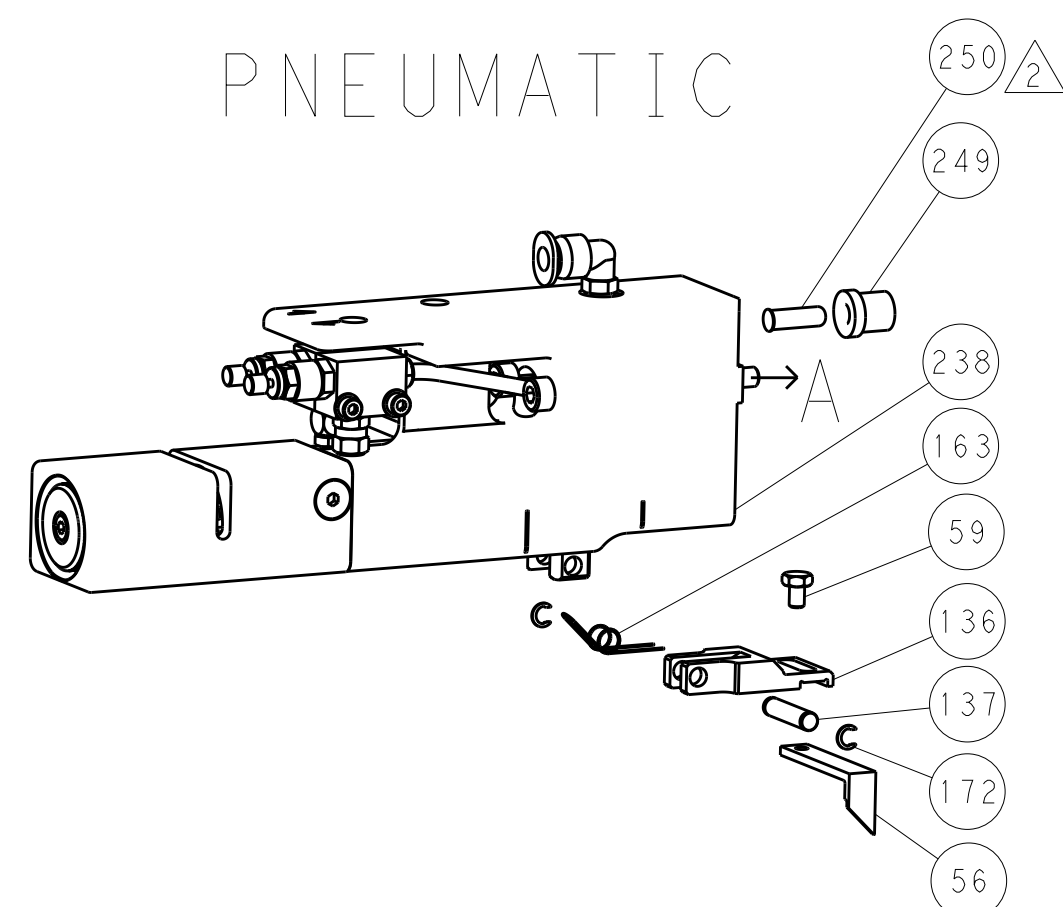
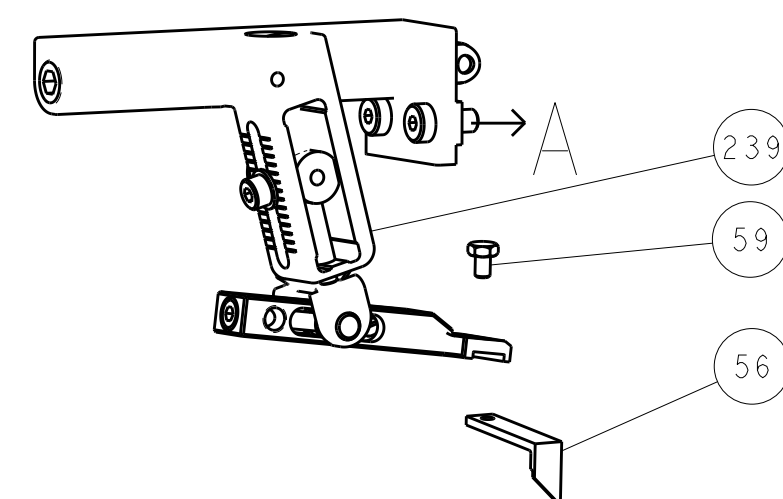
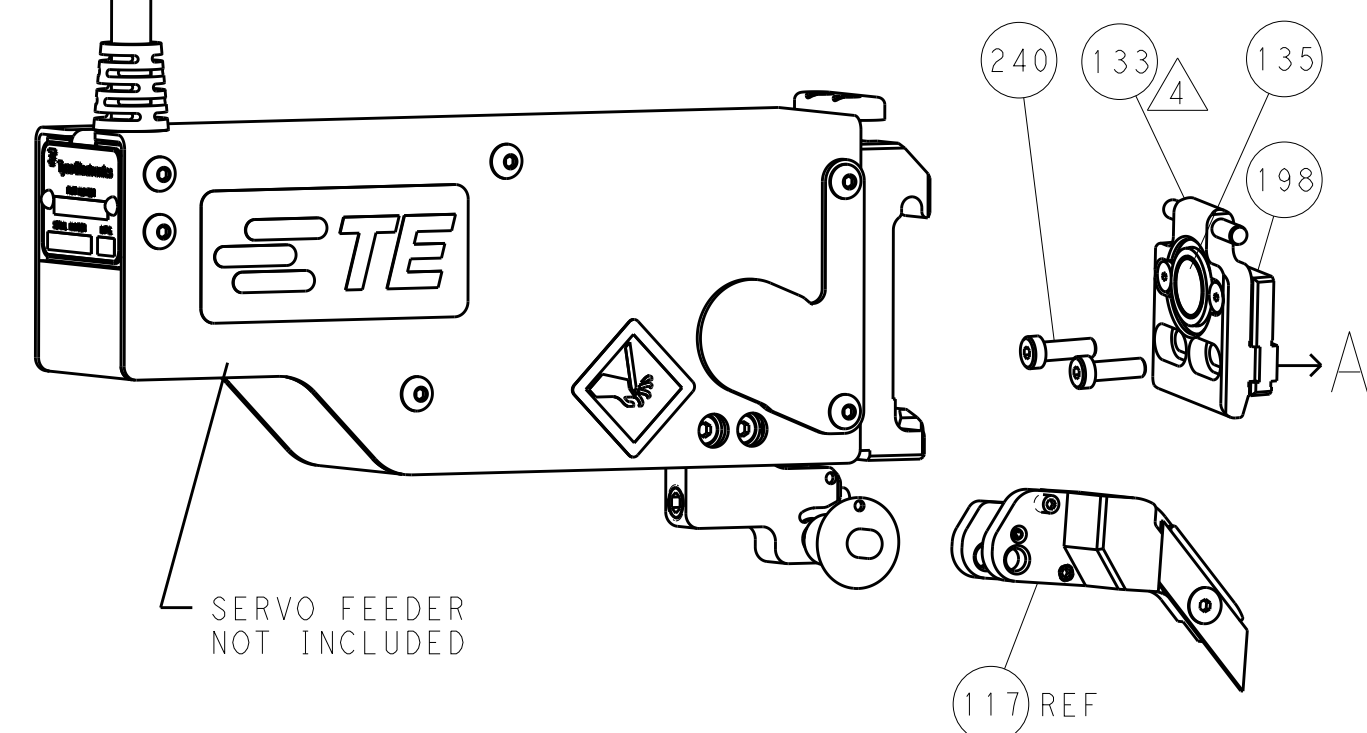
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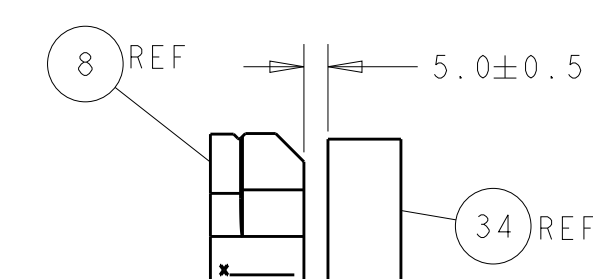
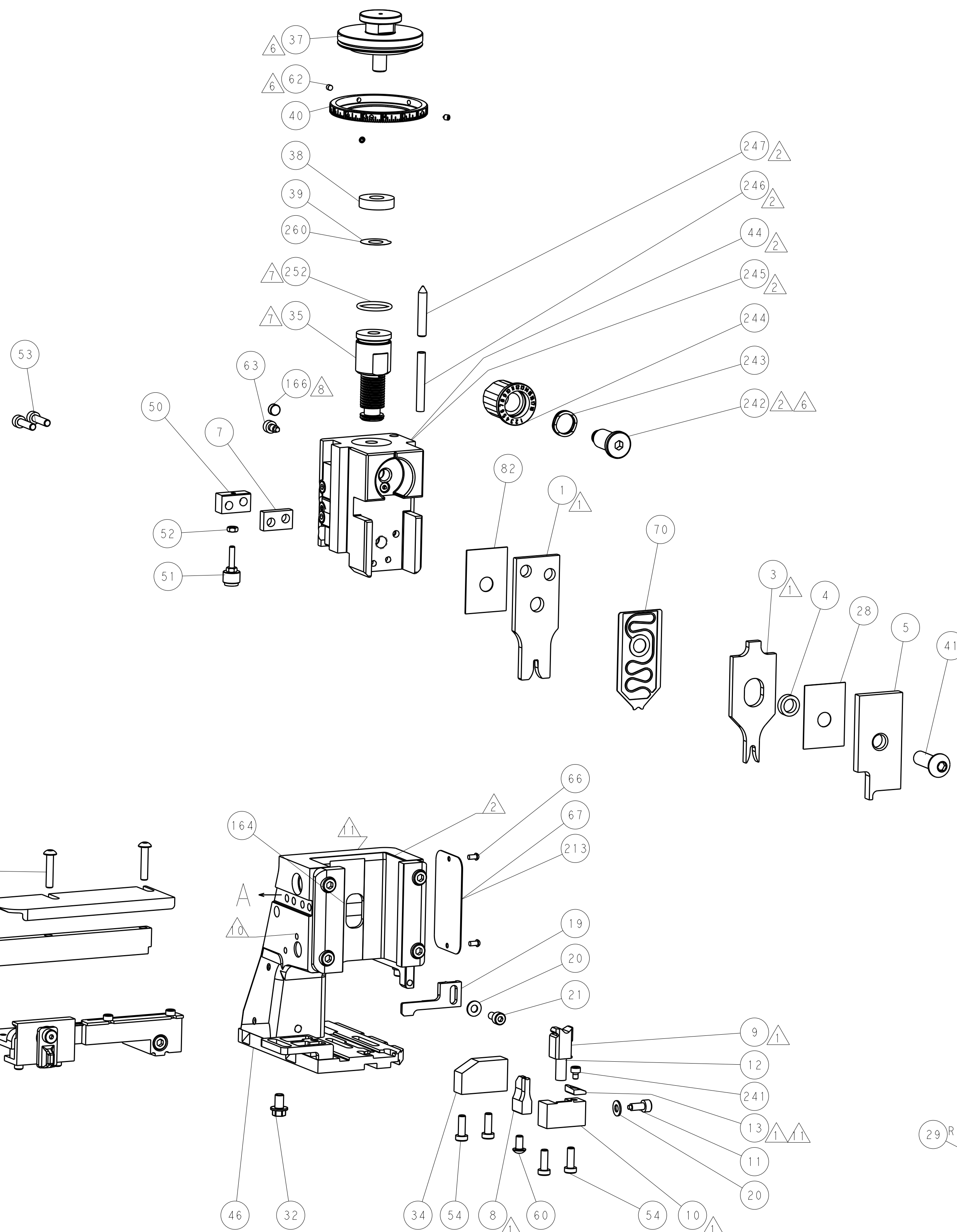
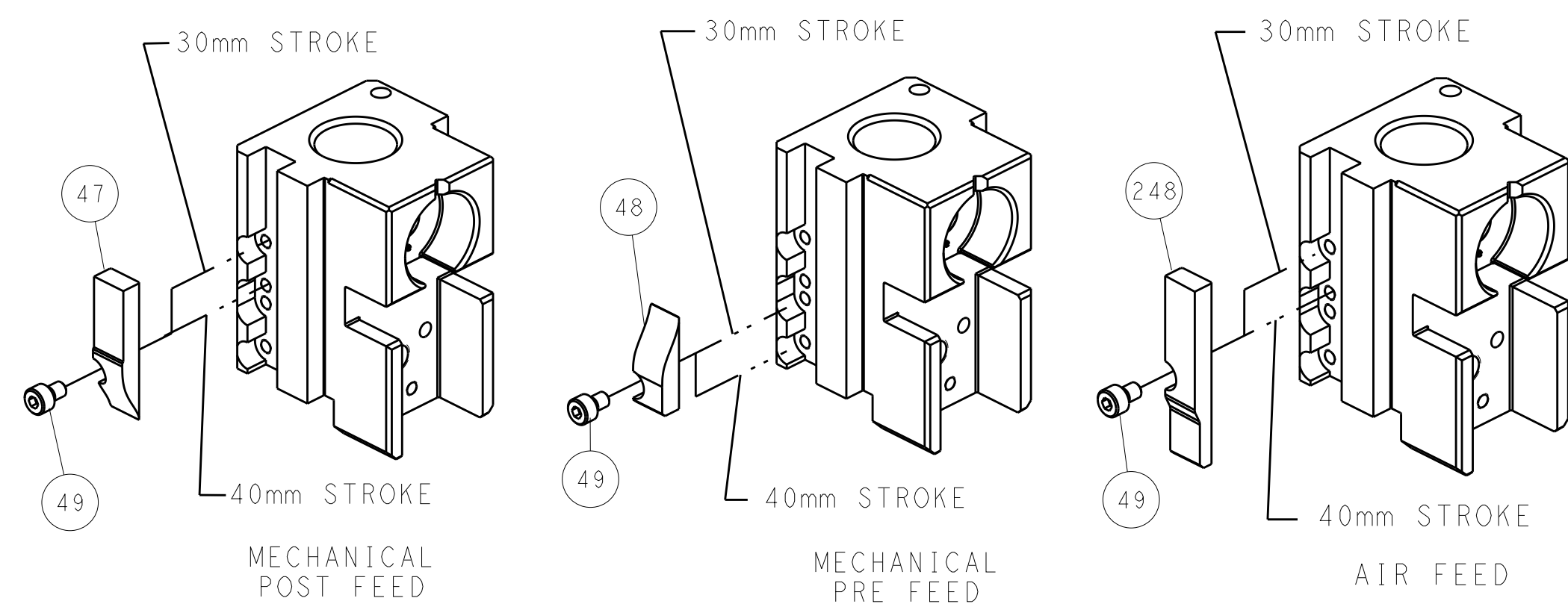
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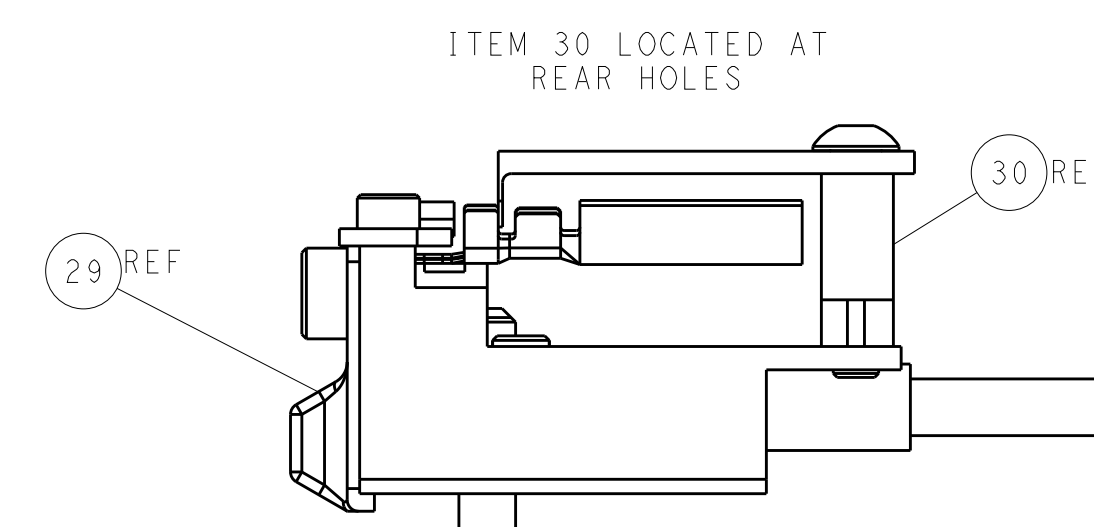
PNEUMATIC

SERVO
LATCH PLATE

CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION GUIDE BY INSULATION BARREL

ATLANTIC VERSION

Shown on sheets 1 of 4 & 2 of 4
(Pacific version shown on sheets 3 of 4 & 4 of 4)

THIS DRAWING IS A CONFIDENTIAL DOCUMENT FOR TFCO INDUSTRIES CORPORATION IT IS SUBJECT TO CHANGE AND THE CONTROLLING ENGINEERING ORGANIZATION SHOULD BE CONSULTED FOR THE LATEST REVISION		DWN <u>P. O. WILSON</u> 030C12014 CHK <u>K. J. STAKEM</u> 080C12014 APVD <u>T. L. FLINN</u> 080C12014		 TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS: mm 		TOLERANCES UNLESS OTHERWISE SPECIFIED: 0 PLC ± 1 PLC ± 2 PLC ± 3 PLC ± 4 PLC ± ANGLES ± FINISH		NAME Ocean Side Feed Applicator -	
MATERIAL -		APPLICATION SPEC - WEIGHT -		SIZE A 00779	
				DRAWING NO C=2266503	
				RESTRICTED TO -	
		Customer Accessible Production Drawing		SCALE 1:2 SHEET 2 OF 4 REV C	

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THIS DRAWING IS UNPUBLISHED.

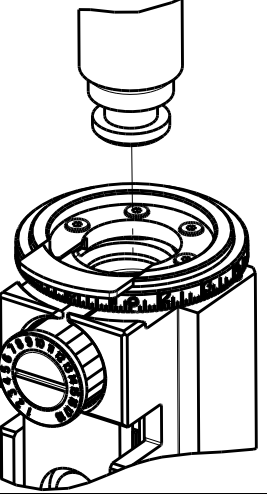
RELEASED FOR PUBLICATION

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PACIFIC VERSION
TERMINATOR
INTERFACE ADAPTER



PART
NUMBER

2-2266503-1

REVISION

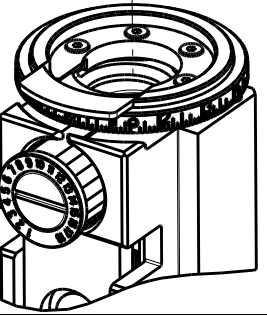
C

DESCRIPTION

FINE CRIMP HEIGHT ADJUST

FEED TYPE

MECHANICAL



2-2266503-2

C

FINE CRIMP HEIGHT ADJUST

PNEUMATIC

2-2266503-5

C

FINE CRIMP HEIGHT ADJUST

SERVO LATCH PLATE⁴

2-2266503-7

C

FINE CRIMP HEIGHT ADJUST

NONE

7-2266503-7

A

CRIMP TOOLING KIT

-

APPLICATOR DATA

CRIMP	SIZE	TYPE
WIRE	2.54 mm [.100]	F
INSUL	3.30 mm [.130]	O

APPLICATOR INSTRUCTIONS

408-10389



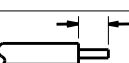
TERMINAL DATA: TE TERMINAL

TE CRIMP SPECIFICATION

TERMINAL NAME: DIA 2.5mm CONTACT

WIRE STRIP LENGTH

4.90-5.60 mm [.193-.220 IN]



INSULATION DIAMETER RANGE

Ø1.90-3.00 mm [.075-.118 IN]

TERMINAL APPLICATION SPECIFICATION

(A)114-18020

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(B)114-18040

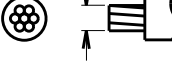
-

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TERMINALS APPLIED

TE TERMINAL	TE TERMINAL	TE TERMINAL	TE TERMINAL
(A) 929964-1	(A) 929971-1	(A) 929971-8	(B) 929987-1
(A) 1-929964-0	(A) 929971-7		(B) 929987-4

WIRE SIZE



CRIMP HEIGHT mm [INCH]



CRIMP HEIGHT REFERENCE SETTING⁹

2.50mm2	1.97+/-0.03 [.078+/- .001]	4.0
2.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.00mm2 + 1.00mm2	1.82+/-0.03 [.072+/- .001]	5.5
1.50mm2	1.67+/-0.03 [.066+/- .001]	7.2
0.50mm2 + 1.00mm2	1.67+/-0.03 [.066+/- .001]	7.2
1.25mm2	1.60+/-0.03 [.063+/- .001]	8.0



RECOMMENDED SPARE PARTS

GREASE BEARING SURFACES LIGHTLY

3. LUBRICATE DAILY PER THE APPLICATOR INSTRUCTION SHEET SUPPLIED WITH THE APPLICATOR.

4

APPLICATOR SPECIFIC DATA TO BE ENTERED INTO BLANK MEMORY CHIP AT ASSEMBLY. SEE BELOW FOR PART NUMBER:
MECHANICAL FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266503-4
PNEUMATIC FEED WITH "SMART APPLICATOR" CONVERSION: 8-2266503-4
SERVO FEED WITH "FINE CRIMP HEIGHT ADJUST": 8-2266503-5

5. ADJUSTMENT OF THE STRIPPER MAY BE REQUIRED WHEN MOVING THE APPLICATOR BETWEEN BENCH AND LEADMAKER APPLICATIONS.

6

APPLY PART NUMBER 1-23419-5 LOCTITE TO THREADS OF ITEM 62.
APPLY PART NUMBER 2-23419-6 LOCTITE TO THREADS OF ITEM 242.

7

GREASE THREADS, GROOVE AND O-RING ON ITEMS 139 & 152.

8

MAGNET MUST BE ORIENTED CORRECTLY IN ORDER TO PROPERLY ACTUATE THE COUNTER.

9

CRIMP HEIGHT REFERENCE SETTING WAS THE SETTING USED WHEN THE APPLICATOR WAS QUALIFIED AT THE FACTORY. ADJUSTMENT MAY BE NECESSARY WHEN RUNNING APPLICATOR IN THE FIELD.

10

SPARE FEED CAM STORAGE LOCATION REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

11

TO CONVERT THE APPLICATOR TO A NON-CARRIER CUTTING STYLE, REMOVE ITEM 13 AND ATTACH TO THE LOCATION ON BACK SIDE OF THE HOUSING. REFER TO INSTRUCTION SHEET FOR ADDITIONAL INFORMATION.

12

FEED ADJUSTMENT REQUIRED WHEN SWITCHING BETWEEN (A) SPEC AND (B) SPEC TERMINALS.

AMP 4805 REV 31MAR2000

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PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

SET UP GAUGE
2119599-1

LOC
A

DIST
66

REVISIONS

P	LTR	DESCRIPTION	DATE	OWN	APVD
-	-	SEE SHEET 1	-	-	-

-	1	1	1	1	2119782-1	FINE ADJUST HEAD ASM, PACIFIC STYLE	251
-	-	-	1	-	2119640-1	PUSH ROD, AIR FEED	250
-	-	-	1	-	1803259-1	BUSHING, FLANGED	249
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THIS DRAWING IS UNPUBLISHED. IT IS SUBJECT TO CHANGE AND THE USER SHALL BE RESPONSIBLE FOR VERIFYING THE DIMENSIONS AND TOLERANCES OF THE PARTS SHOWN ON THIS DRAWING. NO CONTACTS FOR THE LATEST EDITION.

DIMENSIONS:

mm



TOLERANCES UNLESS OTHERWISE SPECIFIED:

0 PLC ±

1 PLC ±

2 PLC ±

3 PLC ±

4 PLC ±

ANGLES ±

FINISH ±

MATERIAL

-

OWN

R.O.WILSON

03OCT2014

CHK

K.J.STAKEM

08OCT2014

APVD

T.L.FLIN

08OCT2014

NAME

Ocean Side Feed Applicator

SIZE

A1

CAGE CODE

00779

DRAWING NO

©=2266503

RESTRICTED TO

-

Customer Accessible Production Drawing

SCALE

1:2

SHEET

3

OF

4

REV

C

TE Connectivity

Harrisburg, PA 17105-3608

SHEETS 1 & 2 ARE NOT REQUIRED FOR PACIFIC VERSION

LOC	DIST	REVISIONS				
		P	LTR	DESCRIPTION	DATE	OWN
A	66	-	-	SEE SHEET 1	-	-

D

C

B

A

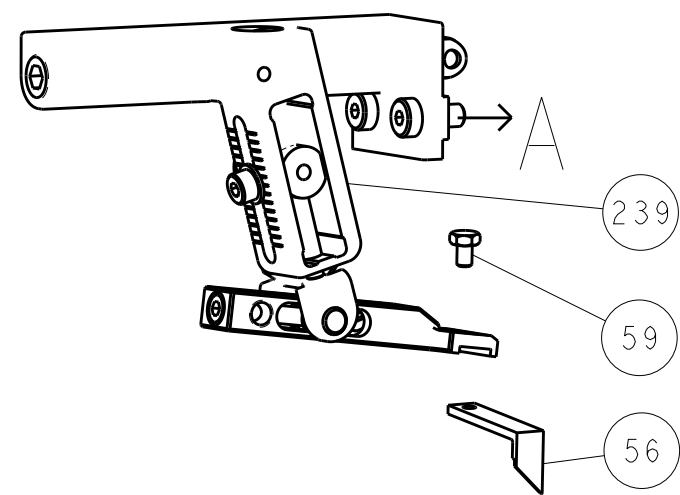
D

C

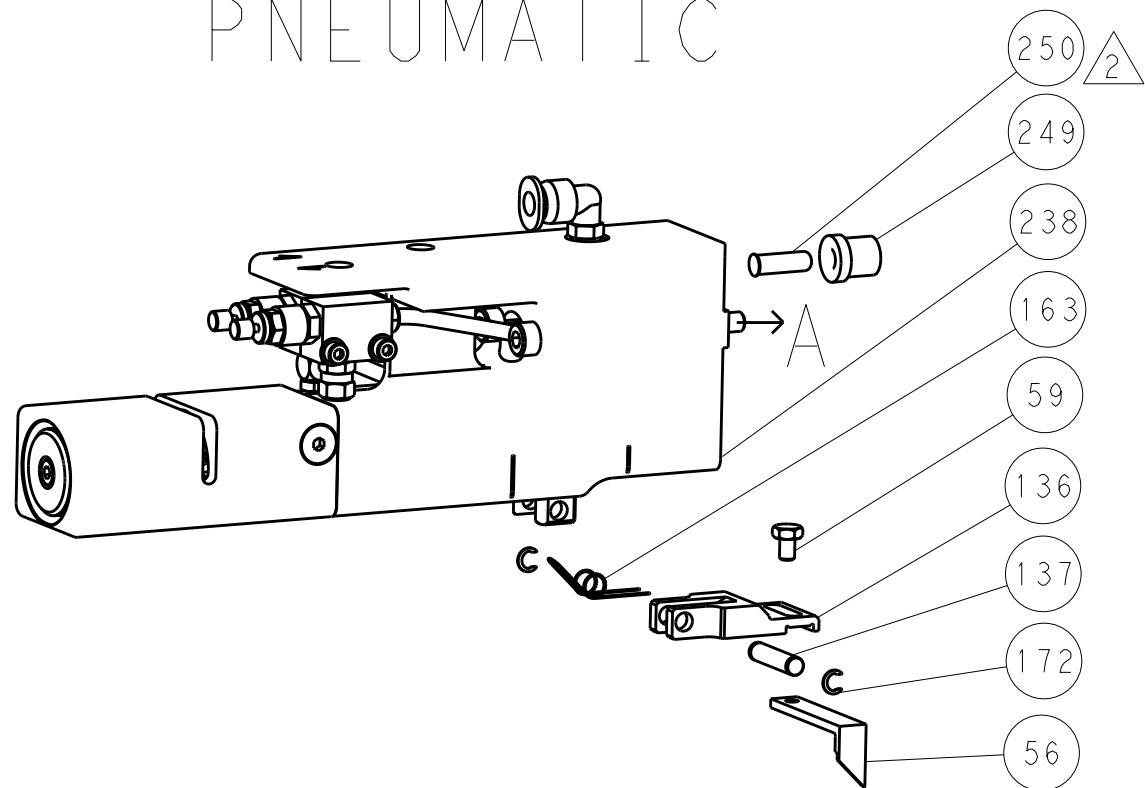
B

A

FEED TYPE MECHANICAL



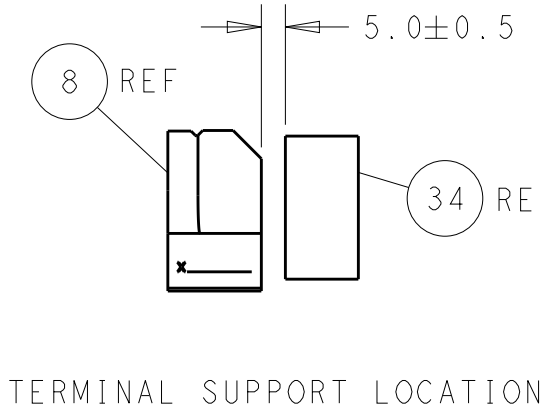
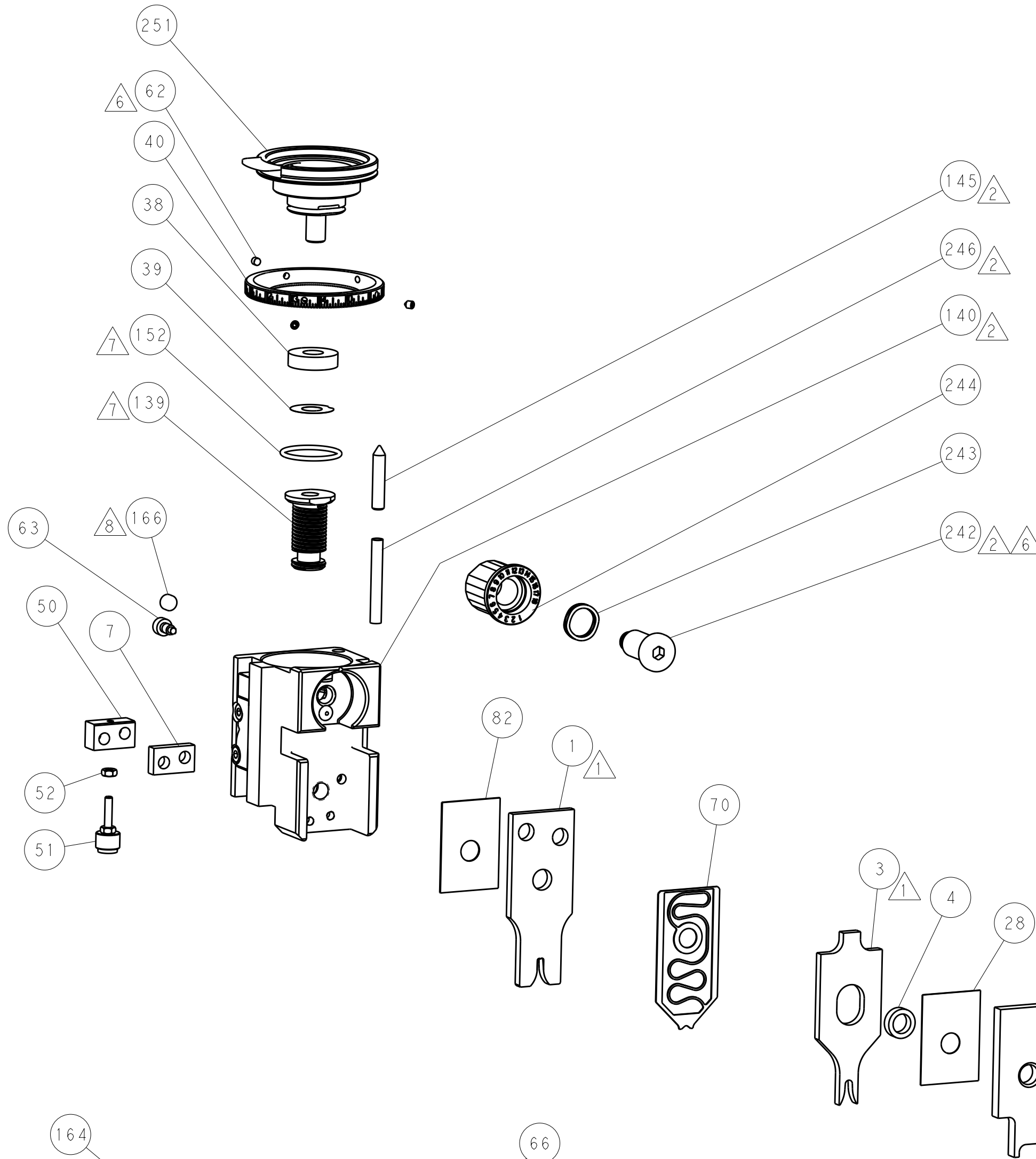
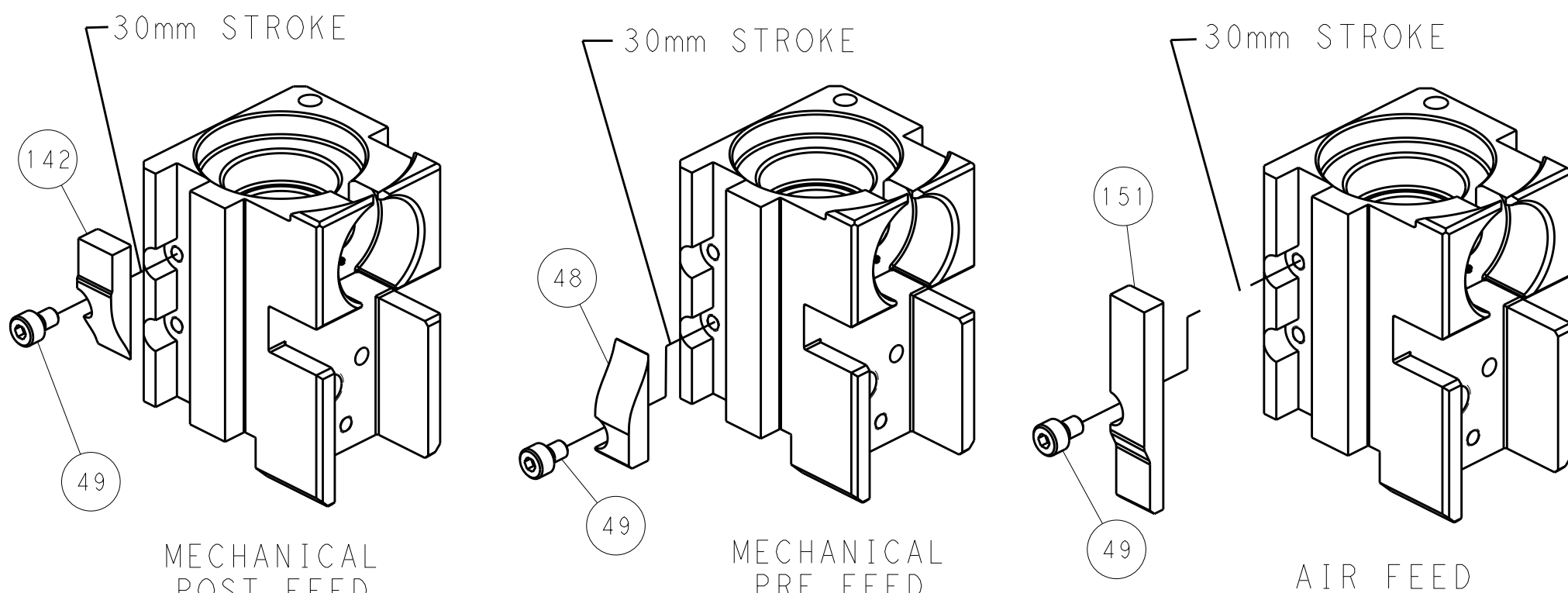
PNEUMATIC



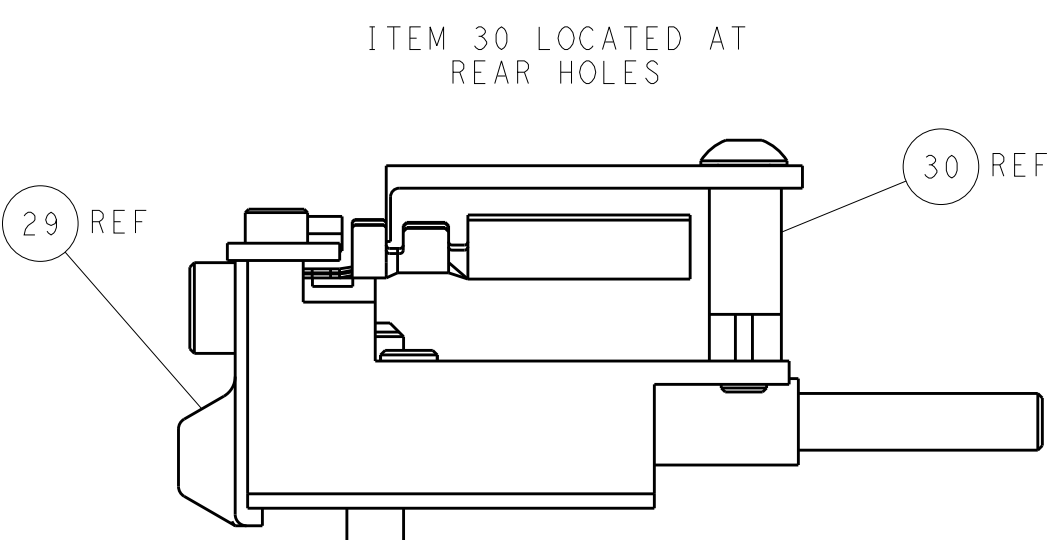
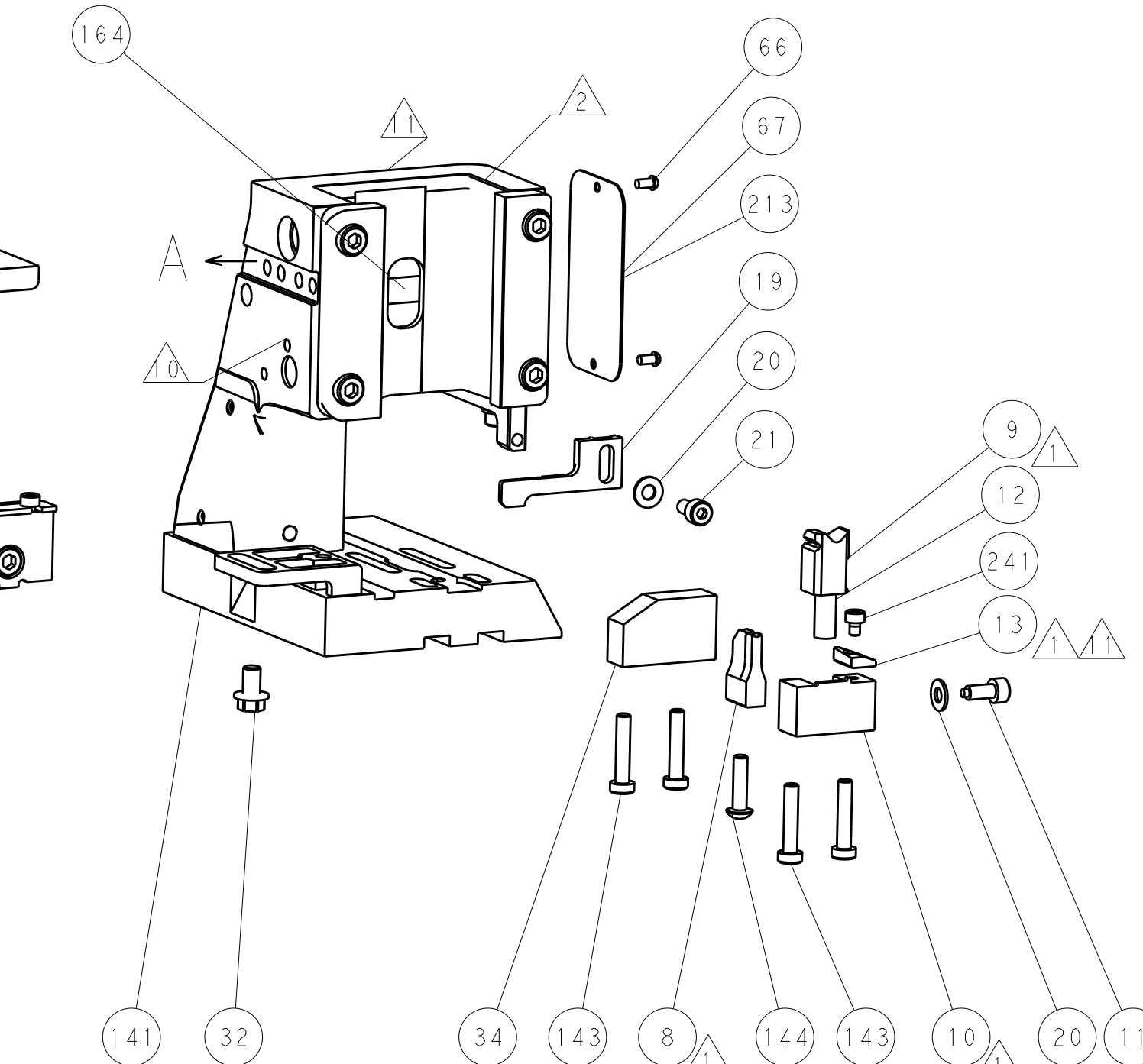
SERVO LATCH PLATE



CAM POSITIONS



TERMINAL SUPPORT LOCATION



FEED TRACK POSITION
GUIDE BY INSULATION BARREL

PACIFIC VERSION
Shown on sheets 3 of 4 & 4 of 4
(Atlantic version shown on sheets 1 of 4 & 2 of 4)

1. NOT DRAWN TO SCALE. SEE DIMENSIONS FOR TOLERANCES. UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED.				DWN R.O.WILSON 03OCT2014		CHK K.J.STAKEM 08OCT2014		APVD T.L.FLIN 08OCT2014		TE Connectivity Harrisburg, PA 17105-3608	
DIMENSIONS:				TOLERANCES UNLESS OTHERWISE SPECIFIED:		NAME		Ocean Side Feed Applicator			
mm						PRODUCT SPEC					